

Work Order ID 128876

128876

Tuesday, January 27, 2015 7:53:01 AM

Page 1

Item ID: D412-709-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Escape Panel Modification Clear Fits LH or RH
 Start Date: 1/20/15 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-29 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D412-709	Rev C

100	Document Control	0.00							
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100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPPD412-709-011 CHG001

110	Pick Kit	0.00							
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110

Packaging

Packaging

Memo

120	QC4- 100% Inspect kits for completeness	0.00							
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120

QC

Quality Control

Memo

0.00

MLS 1504-03

DAS

46

9-89

APR 08 2015

DAS

06

9-89

APR 06 2015

DAS

46

9-89

APR 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 128876

128876

Page 2

Tuesday, January 27, 2015 7:53:01 AM

Item ID: D412-709-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Escape Panel Modification Clear Fits LH or RH
 Start Date: 1/20/15 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-709-011								
	Location: <u>016</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Ship

4

APR 08 2015

DAS
9-85

MLJ

15-04-08

ME

15-4-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 128876

128876

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 1/20/15

Required Date: 1/26/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC IPP Rev:D
10.05.20 added D3561-1 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-20A	DAS 46	Purchased	No			110	Each	56.0000	3	912	DAS 28 9-89	APR 06 2015	DAS 03 9-89
AN6-20A									**				
BOLT	9-89												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST286A		25							
				M128936		25							
				ST334		31							
				M127044		1							
				M130466		30							
D3118-3	DAS 46	Manufactured	No			110	Each	4.0000	1	12x 84	DAS 28 9-89		DAS 03 9-89
D3118-3									**				
Sign Assembly	9-89												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST018		4							
				125312		4							
D3224-1	DAS 46	Manufactured	No			110	Each	8.0000	1	84	DAS 28 9-89		DAS 03 9-89
D3224-1									**				
Frame	9-89												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST441		8							
				123657		8							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐	3/2/2025								
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Tuesday, January 27, 2015 7:53:00 AM

Work Order ID: 128876

128876

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 1/20/15

Required Date: 1/26/15

Start Qty: 3.00

Required Qty: 3.00

D3239-1 Manufactured No

110 Each 23.0000 2

68

DAS 03 9-89

4 ***D3239-1*** DAS
Cover 46
9-89

**

DAS
28
9-89

APR 06 2015

Location Loc Qty Loc Code

ST031 23
120158 9
127364 14

D412-709-013 Manufactured No

110 Each 2.0000 1

8

DAS
28
9-89

4 ***D412-709-013*** DAS
Escape Panel Push-Out Window Clear Fits LH or RH 46
9-89

**

Location Loc Qty Loc Code

FG016 2
120137 2

127345

DAS
03
9-89

MS21042L3 Purchased No

110 Each 2,639.000 2

68

DAS
28
9-89

4 ***MS21042L3***
Nut

DAS
46
9-89

**

Location Loc Qty Loc Code

FP001 420
M130922 420
ST305 2216
M130799 11
M131264 1205
M131317 1000
ST307 3
123900 3

131624

DAS
03
9-89

DQA: _____ Date: _____



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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Work Order ID: 128876

128876

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 1/20/15

Required Date: 1/26/15

Start Qty: 3.00

Required Qty: 3.00

MS21042L6 Purchased No 110 Each 320.0000 3 **DAS 28 9-89** **APR-06 2015**

MS21042L6 DAS 46 9-89
Nut

Location	Loc Qty	Loc Code
ST304	200	
m131317	200	
ST305	120	
m129909	20	
m130799	100	

MS35207-262 Purchased No 110 Each 43.0000 2 **DAS 28 9-89** **DAS 28 9-89**

MS35207-262 DAS 46 9-89
Screw

Location	Loc Qty	Loc Code
ST276	43	
M130281	43	

NAS1149D0332J Purchased No 110 Each 1,752.000 2 **DAS 28 9-89** **DAS 28 9-89**

NAS1149D0332J DAS 46 9-89
Washer

Location	Loc Qty	Loc Code
CA	14	
m129682	14	
ST269	1738	
m130325	1738	

NAS1149D0616J Purchased No 110 Each 316.0000 5 **DAS 28 9-89** **DAS 28 9-89**

NAS1149D0616J DAS 46 9-89
WASHER

Location	Loc Qty	Loc Code
ST269	316	
122815	316	

DQA: _____ Date: _____



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Work Order ID: 128876

128876

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 1/20/15

Required Date: 1/26/15

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0663J

Purchased

No

110

Each

295.0000

5

1/20

DAS
28
9-89

APR 06 2015

NAS1149D0663.J

DAS
46
9-89

Washer

Location

Loc Qty

Loc Code

ST269

295

M126334

295

131618

DAS
88
9-89

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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

REFERENCE ONLY

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1				1			D3118-3	SIGN ASSEMBLY
	1						D3136-041	WINDOW ASSEMBLY
							D3136-043	WINDOW ASSEMBLY
1							D3224-1	FRAME
			1				D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
	1			1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0980	SEAL FILLER
2							D3239-1	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1			1		1	D3561-1	WINDOW SEAL TOOL
3							AN6-20A	BOLT
2							AN960JD10L	WASHER
5							AN960JD616	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW

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